

Date: Friday, 2/23/2007 1:48:44 PM  
User: Kim Johnston

# Process Sheet

|                       |  |                  |                     |
|-----------------------|--|------------------|---------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services  | Drawing Name     | : AFT TUBE ASSEMBLY |
| Job Number            | : 30931  |                  |                     |
| Estimate Number       | : 10699  |                  |                     |
| P.O. Number           | : <u>N/A</u>   | Part Number      | : D3391025          |
| This Issue            | : 2/23/2007  | S.O. No.         | : <u>N/A</u>        |
| Prsht Rev.            | : NC   | Drawing Number   | : D3391 REV E       |
| First Issue           | : <u>N/A</u>   | Project Number   | : N/A               |
| Previous Run          | : 30699  | Drawing Revision | : E                 |
|                       |  | Material         | : <u>N/A</u>        |
| Written By            | : <u>[Signature]</u>   | Due Date         | : 3/21/2007         |
| Checked & Approved By | : <u>[Signature]</u>   | Qty:             | 1 Um: Each          |
| Comment               | Est Rev: B 06-02-07 ECN773 dwg rev. D EC<br>Est Rev: C 06-03-28 Update Manufacturing Instructions<br>JLM |                  |                     |

## Additional Product

Job Number:



|         |                       |              |
|---------|-----------------------|--------------|
| Seq. #: | Machine Or Operation: | Description: |
|---------|-----------------------|--------------|

|     |          |                    |
|-----|----------|--------------------|
| 1.0 | D6014090 | ALUMINUM EXTRUSION |
|-----|----------|--------------------|



Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

|     |             |             |               |
|-----|-------------|-------------|---------------|
| Qty | Part Number | Description | Batch         |
| 1   | D6014-090   | Extrusion   | <u>B06546</u> |

Identify as D3391-3

2F 07/03/09

|     |            |                            |
|-----|------------|----------------------------|
| 2.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
|-----|------------|----------------------------|



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599 Rev: AA & Dwg D3391 Rev: E

2F 07/03/09

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2F 07/03/09

|     |       |                                |
|-----|-------|--------------------------------|
| 4.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: E

2-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

3-Deburr

JL 107/03/13

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)   |                             |   |                 |                           |                       |                          |
|----------|------|--|-----------------------------|---|-----------------|---------------------------|-----------------------|--------------------------|
| DATE     | STEP | Description of NC<br>Section A   | Corrective Action Section B |   |                 | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|          |      |  | Initial<br>Chief Eng        | Action Description<br>Chief Eng   | Sign &<br>Date  |                           |                       |                          |
| 07/03/13 | 4    | - dimension 3.300 $\pm$ .010 is 3.318<br>- dimension 3.520 $\pm$ .010 is 3.537 | Posian                      | API section was tested in mil tube 1530930. API tube is acceptable, the fit is very good. | J.L<br>07/03/13 | Posian                    | Posian                | Posian                   |
|          |      |  |                             |   |                 |                           |                       |                          |
|          |      |  |                             |   |                 |                           |                       |                          |

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 30931

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 07/03/13

1

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

owl 07/03/13

1

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DP

7-3-13

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 7-3-14

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

Pm 07-03-14

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

Pm 07-03-14

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

Pm 07-03-14

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

Pm 07-03-15

5-Deburr

Pm 07-03-15

Tools: rill

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/14

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HS/m-h

07-03-20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |  |                                 |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|--|---------------------------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |  |                                 | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        |  | Action Description<br>Chief Eng |                           |                       |                          |
|      |      |                                  |                             |  |                                 |                           |                       |                          |
|      |      |                                  |                             |  |                                 |                           |                       |                          |
|      |      |                                  |                             |  |                                 |                           |                       |                          |

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 30931

Part Number: D3391025

Jgb Number:



Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



103 141



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

07-03-29 ①

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



①

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

07/03/29

14.0

NAS1330C3KB166

INSERT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

8 NAS1330C3KB166 Insert M100732.

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per dwg

FL

07/03/29 ①

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 07 03 30

①

17.0

AESS10KB366

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Insert

Pick:

Qty Part Number Description Batch

14 AESS10KB366 Insert M103758

18.0

AESS10KB266

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 AESS10KB266 Insert M17905

or NAS1330C3KB266

FL

07/03/29 ①

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |  |                                 |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|--|---------------------------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |  |                                 | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        |  | Action Description<br>Chief Eng |                           |                       |                          |
|      |      |                                  |                             |  |                                 |                           |                       |                          |
|      |      |                                  |                             |  |                                 |                           |                       |                          |
|      |      |                                  |                             |  |                                 |                           |                       |                          |

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 30931

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AESS10KB316

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

| Qty | Part Number       | Description | Batch  |
|-----|-------------------|-------------|--------|
| 2   | AESS10KB316       | Insert      | m17905 |
|     | or NAS1330C3KB316 |             |        |

20.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

| Qty | Part Number | Description | Batch  |
|-----|-------------|-------------|--------|
| 1   | D2646       | Aft Cap     | B30119 |

21.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

| Qty | Part Number | Description | Batch   |
|-----|-------------|-------------|---------|
| 2   | AN3C4A      | Bolt        | M103691 |

22.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

Pick:

| Qty | Part Number | Description | Batch   |
|-----|-------------|-------------|---------|
| 2   | AN960C10L   | Washer      | M103691 |

23.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

| Qty | Part Number | Description | Batch   |
|-----|-------------|-------------|---------|
| 2   | NAS1515H3L  | Washer      | M103641 |

m.h 07/03/31

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 30931

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291

Sikaflex expiry date:

M163497

07/10

M-R 07/03/31

①

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Joelou@

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP

B30360

07/14/04

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/14/04

Job Completion



U 87-04-04

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

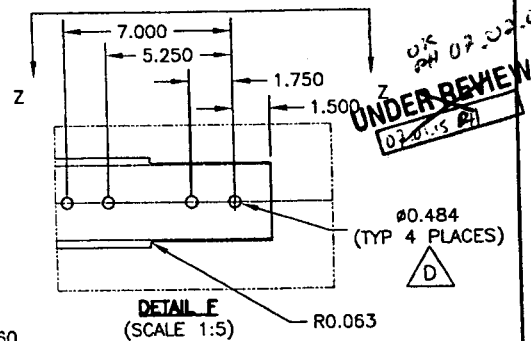
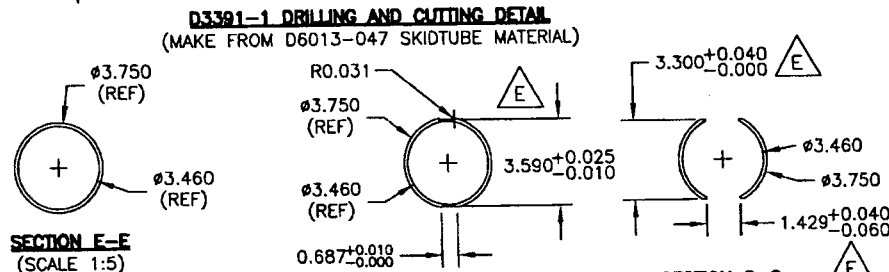
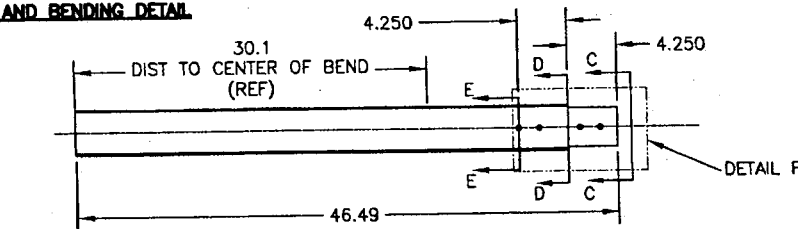
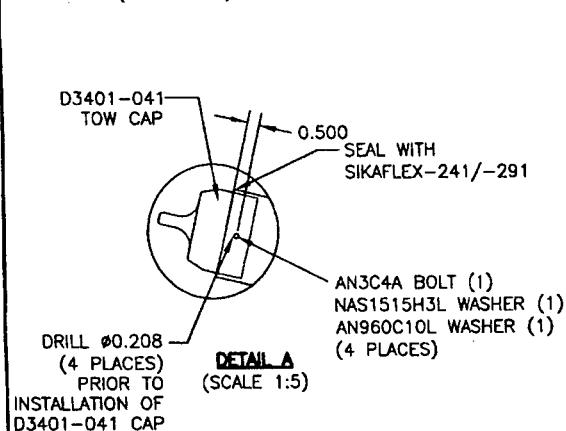
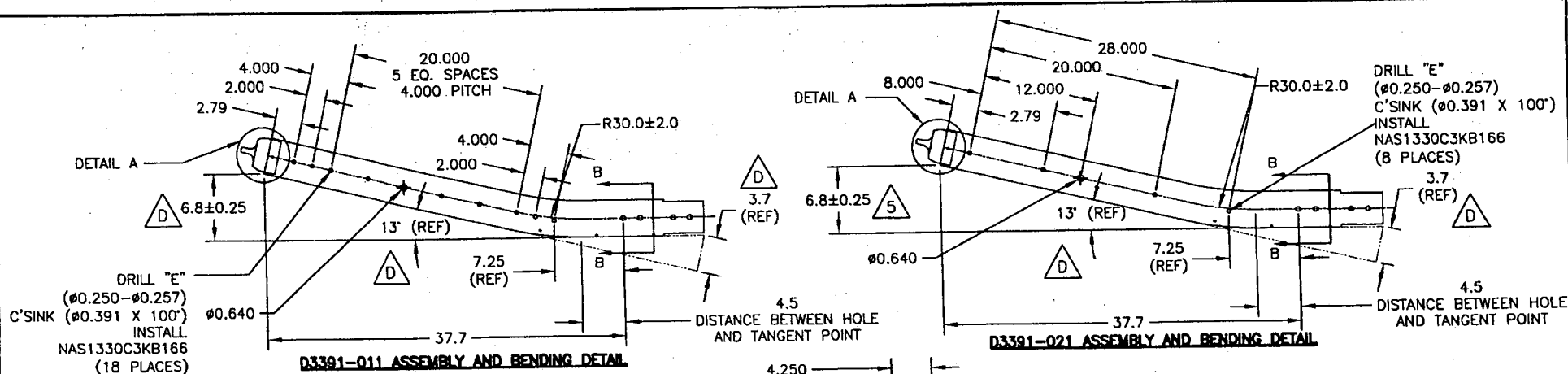
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |  |                                 |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|--|---------------------------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |  |                                 | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           |  | Action Description<br>Chief Eng |                           |                       |                          |
|      |      |                                  |                                |  |                                 |                           |                       |                          |
|      |      |                                  |                                |  |                                 |                           |                       |                          |
|      |      |                                  |                                |  |                                 |                           |                       |                          |

NOTE: Date & initial all entries





# **D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST**

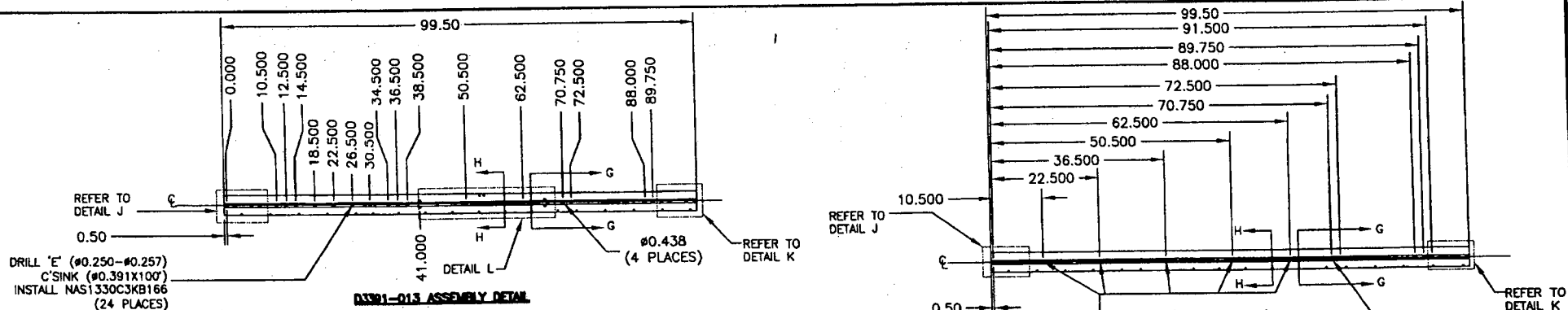
| QTY - 011 | QTY - 021 | PART NUMBER    | DESCRIPTION       |
|-----------|-----------|----------------|-------------------|
| X         | X         | D3391-011      | FWD TUBE ASSEMBLY |
|           |           | D3391-021      | FWD TUBE ASSEMBLY |
| 1         | 1         | D8C13-047      | FWD TUBE          |
| 1         | 1         | D3401-041      | TOW CAP           |
| 4         | 4         | AN3C4A         | BOLT              |
| 4         | 4         | NAS1515H3L     | WASHER            |
| 4         | 4         | AN960C10L      | WASHER            |
| 24        | 14        | NAS1330C3KB166 | INSERT            |

5 DRILL "E"  
(Ø0.250-Ø0.257)  
C'SINK (Ø0.391 X 100")  
INSTALL  
NAS1330C3KB166  
(6 PLACES)

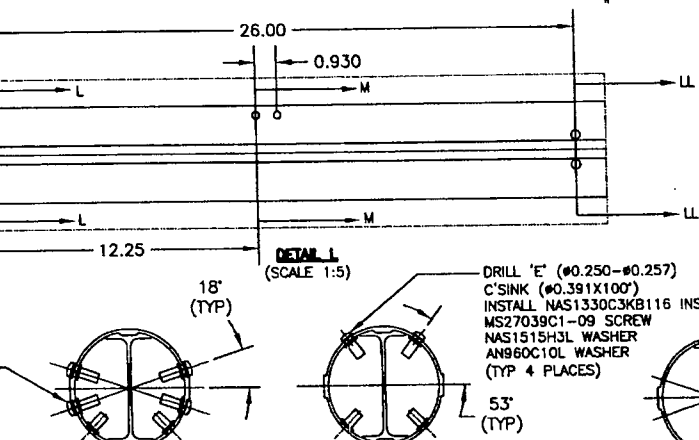
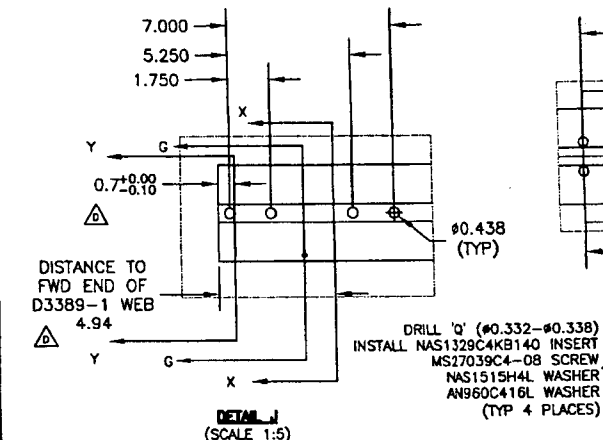
**DESIGN** PH **DRAWN BY** PH **DART** **DART AEROSPACE USA, INC.**  
PORT HADLOCK, MA

**CHECKED** # **APPROVED** # **DRAWING NO.** D3391 **REV. E**  
**DATE** 06.04.25 **TITLE** 412 FLOAT SKIDTUBE **SHEET 2 OF 5**  
**SCALE** 1:10

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 1110931

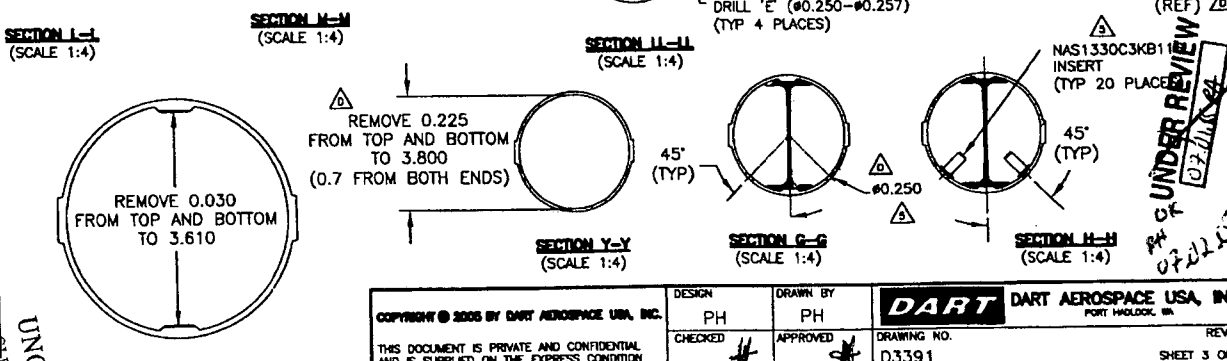


RELEASED  
06.05.01



**D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST**

| QTY - 013 | QTY - 023 | PART NUMBER    | DESCRIPTION       |
|-----------|-----------|----------------|-------------------|
| X         |           | D3391-013      | MID TUBE ASSEMBLY |
|           | X         | D3391-023      | MID TUBE ASSEMBLY |
| 1         | 1         | D2500-1-100    | EXTRUSION         |
| 1         | 1         | D3389-1        | WEB               |
| 24        | 20        | NAS1330C3KB116 | INSERT            |
| 24        | 10        | NAS1330C3KB166 | INSERT            |
| 4         |           | NAS1329C4KB140 | INSERT            |
| 4         |           | NAS1515H3L     | WASHER            |
| 4         |           | AN980C10L      | WASHER            |
| 4         |           | NAS1515H4L     | WASHER            |
| 4         |           | AN960C416L     | WASHER            |
| 4         |           | MS27039C1-08   | SCREW             |
| 4         |           | MS27039C4-08   | SCREW             |



**D3391-013/-023 MID TUBE ASSEMBLY**

1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION

2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 01515

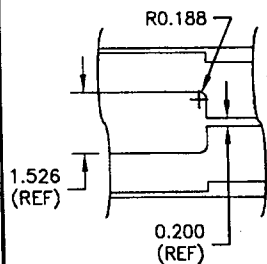
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
NO. 30431  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

**Copyright © 2005 by DART Aerospace USA, Inc.**

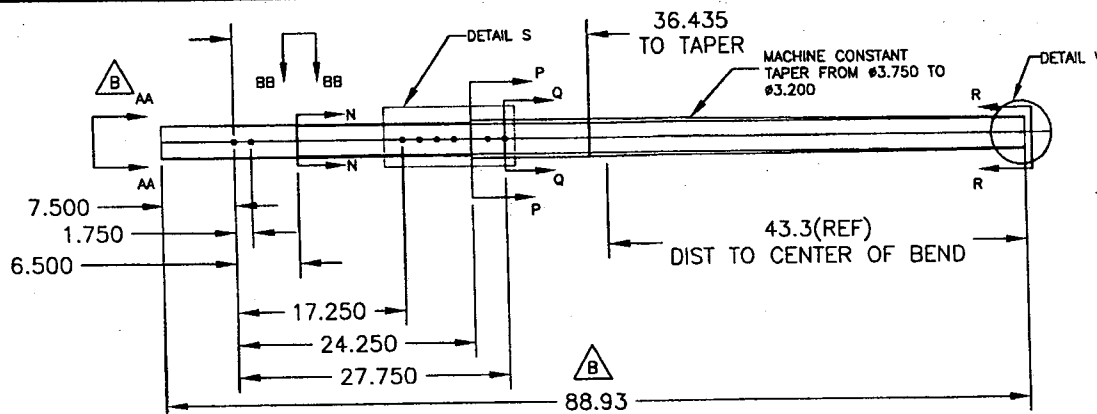
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|                  |                             |  |
|------------------|-----------------------------|--|
| DESIGN<br>PH     | DRAWN BY<br>PH              | <b>DART</b> DART AEROSPACE USA, INC.<br>PORT HADLOCK, MA |
| CHECKED<br>#     | APPROVED<br>#               | DRAWING NO.<br>D3391                                     |
| DATE<br>06.04.25 | TITLE<br>412 FLOAT SKIDTUBE | REV. E<br>SHEET 3 OF 5<br>SCALE<br>1:20                  |

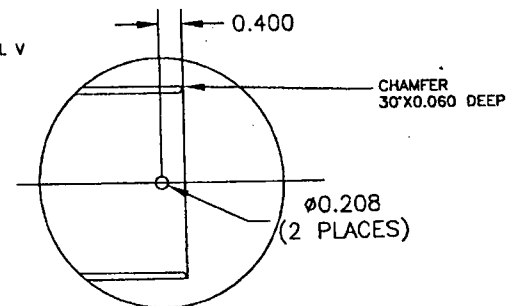
UNDER REVIEW  
07.22.07



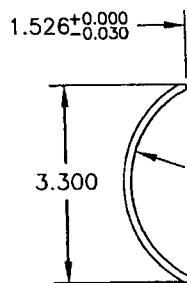
VIEW BB-BB  
(SCALE 1:3)



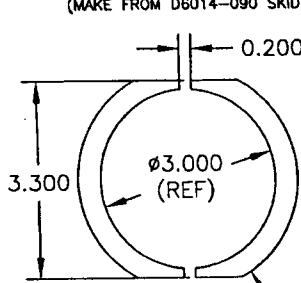
D3391-3 AFT DRILLING AND CUTTING DETAIL  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



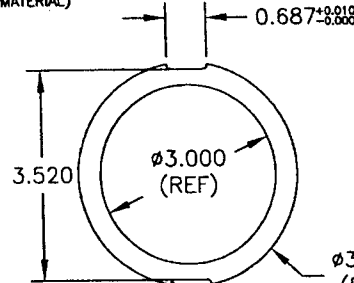
DETAIL V  
(SCALE 1:2)



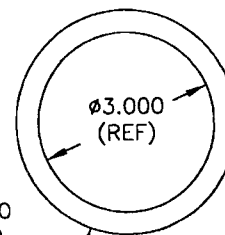
SECTION AA-AA  
(SCALE 1:2)



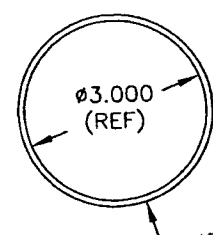
SECTION N-N  
(SCALE 1:2)



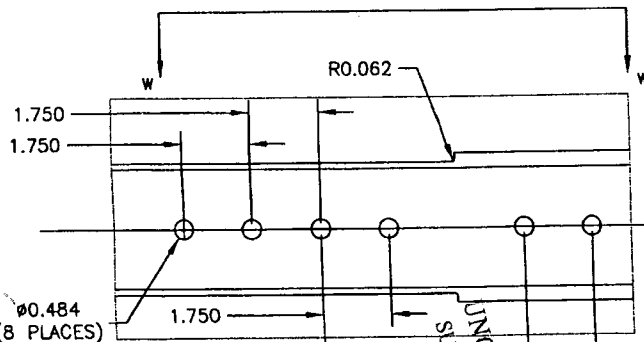
SECTION P-P  
(SCALE 1:2)



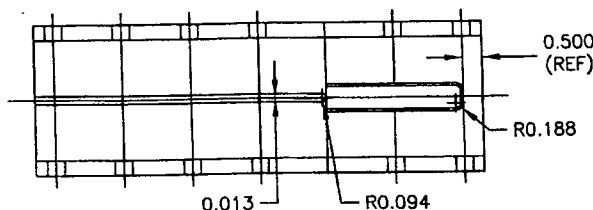
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(SCALE 1:2)



SECTION R-R  
(SCALE 1:2)



DETAIL S  
(SCALE 1:3)



VIEW W-W  
(SCALE 1:3)

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UNDER REVIEW  
07.01.15 011

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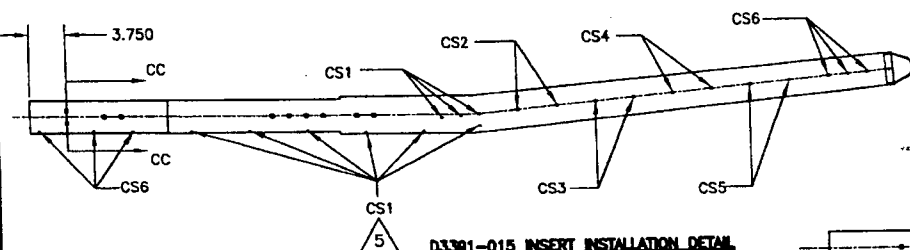
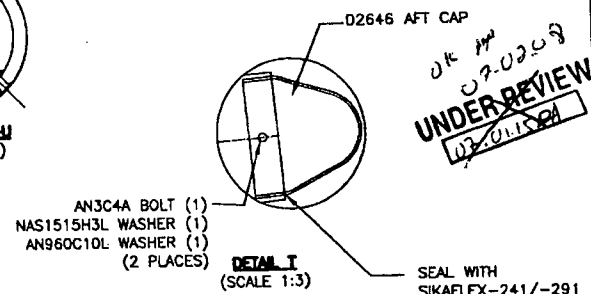
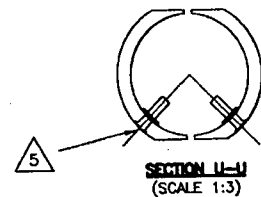
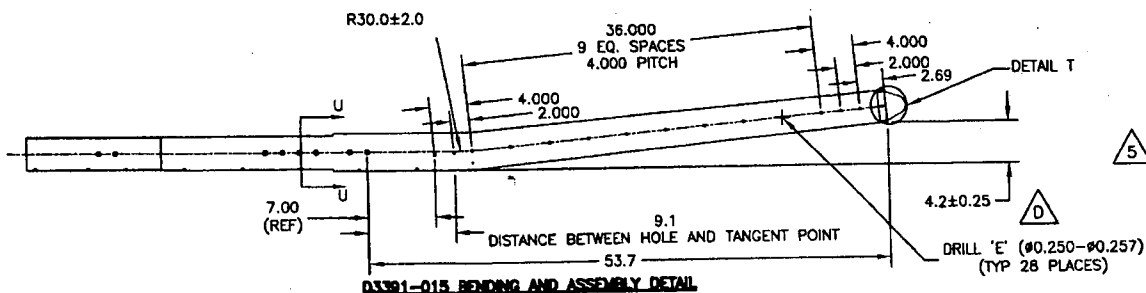
26.05.03

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| DATE    | 06.04.25 | TITLE    | 412 FLOAT SKIDTUBE | REV. E<br>SHEET 4 OF 5<br>SCALE<br>1:12                  |

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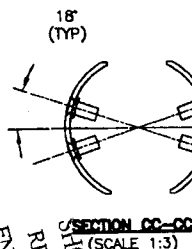
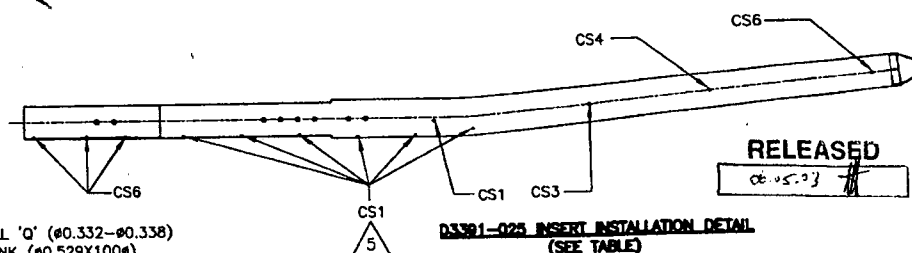
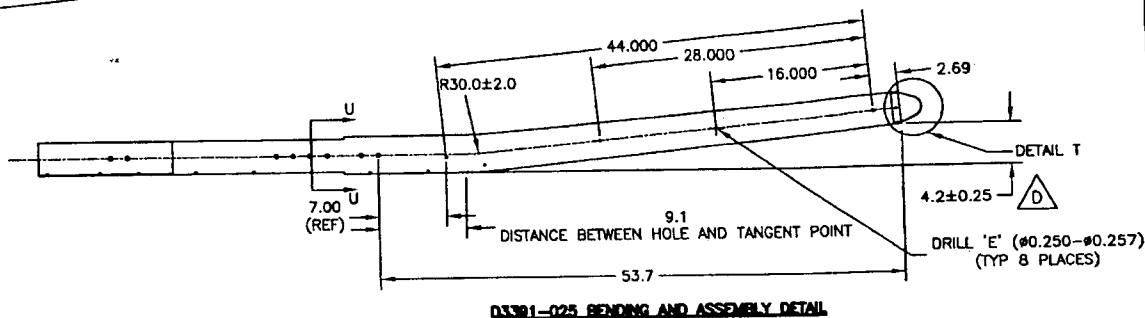


C'SINK AND INSTALL AESS10KBXXX AND/OR NAS1330C3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

| HOLES MARKED | QTY | D3391-015 | QTY | D3391-025 | C'SINK | P/N            |
|--------------|-----|-----------|-----|-----------|--------|----------------|
| CS1          | 18  |           | 14  |           | Ø0.425 | AESS10KB396    |
| CS2          | 2   |           |     |           | Ø0.391 | AESS10KB396    |
| CS3          | 2   |           | 2   |           | Ø0.391 | NAS1330C3KB316 |
| CS4          | 2   |           | 2   |           | Ø0.391 | NAS1330C3KB266 |
| CS5          | 2   |           |     |           | Ø0.391 | NAS1330C3KB216 |
| CS6          | 12  |           | 8   |           | Ø0.391 | NAS1330C3KB166 |

#### D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

| QTY - 015 | QTY - 025 | PART NUMBER    | DESCRIPTION       |
|-----------|-----------|----------------|-------------------|
| X         |           | D3391-015      | AFT TUBE ASSEMBLY |
|           | X         | D3391-025      | AFT TUBE ASSEMBLY |
| 1         | 1         | D6014-090      | AFT TUBE          |
| 1         | 1         | D2646          | AFT CAP           |
| 18        | 14        | AESS10KB396    | INSERT            |
| 4         | 2         | NAS1330C3KB316 | INSERT            |
| 4         | 2         | NAS1330C3KB266 | INSERT            |
| 4         |           | NAS1330C3KB216 | INSERT            |
| 12        | 8         | NAS1330C3KB166 | INSERT            |
| 4         |           | NAS1330C4KB151 | INSERT            |
| 2         | 2         | AN3C4A         | BOLT              |
| 2         | 2         | NAS1515H3L     | WASHER            |
| 2         | 2         | AN960C10L      | WASHER            |



DRILL 'O' (Ø0.332-Ø0.338)  
C'SINK (Ø0.529X100#)  
NAS1330C4KB151 INSERT (1)  
(4 PLACES)

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|                                   |        |                      |
|-----------------------------------|--------|----------------------|
| DART AEROSPACE LTD                |        | Work Order: 30931    |
| Description: Float Skidtube (412) |        | Part Number: D3391-3 |
| Inspection Dwg: D3391             | Rev: E | Page 1 of 1          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance                | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|--------------------------|------------------|--------|--------|----------------------|----------|
| 14.000            | +/-0.010                 | 14.000           | ✓      |        |                      |          |
| 3.500             | +/-0.010                 | 3.500            | ✓      |        |                      |          |
| 88.93             | +/-0.030                 | 88.93            | ✓      |        |                      |          |
| 44.995            | +/-0.030                 | 45.00            | ✓      |        |                      |          |
| 3.200             | +/-0.010                 | 3.210            | ✓      |        |                      |          |
| 1.526             | +0.000/-0.030            | 1.520            | ✓      |        |                      |          |
| 0.200             | +/-0.010                 | .205             | ✓      |        |                      |          |
| 7.500             | +/-0.010                 | 7.499            | ✓      |        |                      |          |
| 27.750            | +/-0.010                 | 27.750           | ✓      |        | m-tape               |          |
| 31.750            | +/-0.010                 | 31.750           | ✓      |        | "                    |          |
| 35.250            | +/-0.010                 | 35.250           | ✓      |        | "                    |          |
| 0.400             | +/-0.010                 |                  |        |        |                      |          |
| <del>0.200</del>  | <del>+0.005/-0.001</del> |                  |        |        |                      |          |
| 3.300             | +/-0.010                 | 3.318            | ✓      |        |                      |          |
| 0.200             | +/-0.010                 | .205             | ✓      |        |                      |          |
| 3.520             | +/-0.010                 | 3.537            | ✓      |        |                      |          |
| 0.687             | +0.010/-0.000            | .689             | ✓      |        |                      |          |
| R0.062            | +/-0.010                 | 1.062            | ✓      |        |                      |          |
| Ø0.484            | +0.005/-0.001            | .486             | ✓      |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |

|                              |                          |                     |     |
|------------------------------|--------------------------|---------------------|-----|
| Measured by: <i>AS/BC/SL</i> | Audited by: <i>AS/BC</i> | Prototype Approval: | N/A |
| Date: 07/03/09               | Date: 07/03/13           | Date:               | N/A |

| Rev | Date     | Change                  | Revised by | Approved |
|-----|----------|-------------------------|------------|----------|
| A   | 06.04.24 | New Issue P/O D3391-025 | KJ/JLM     |          |
| B   | 06.06.19 | Dwg revision update     | KJ/JLM     |          |